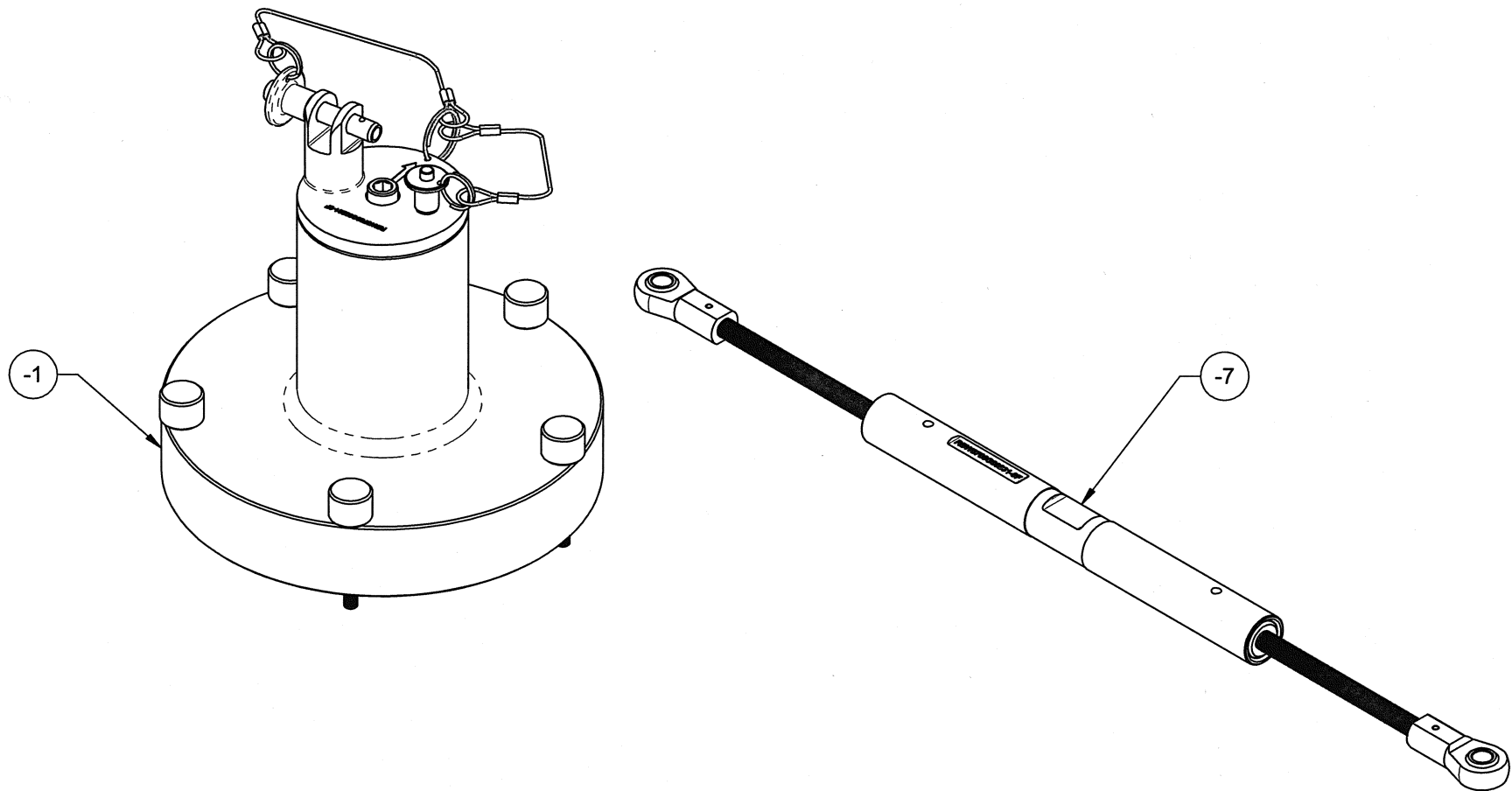


ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6700G09231-6F-1	MAIN ROTOR ADAPTER
-7	1	RBW6700G09231-6F-7	CONNECTING ROD

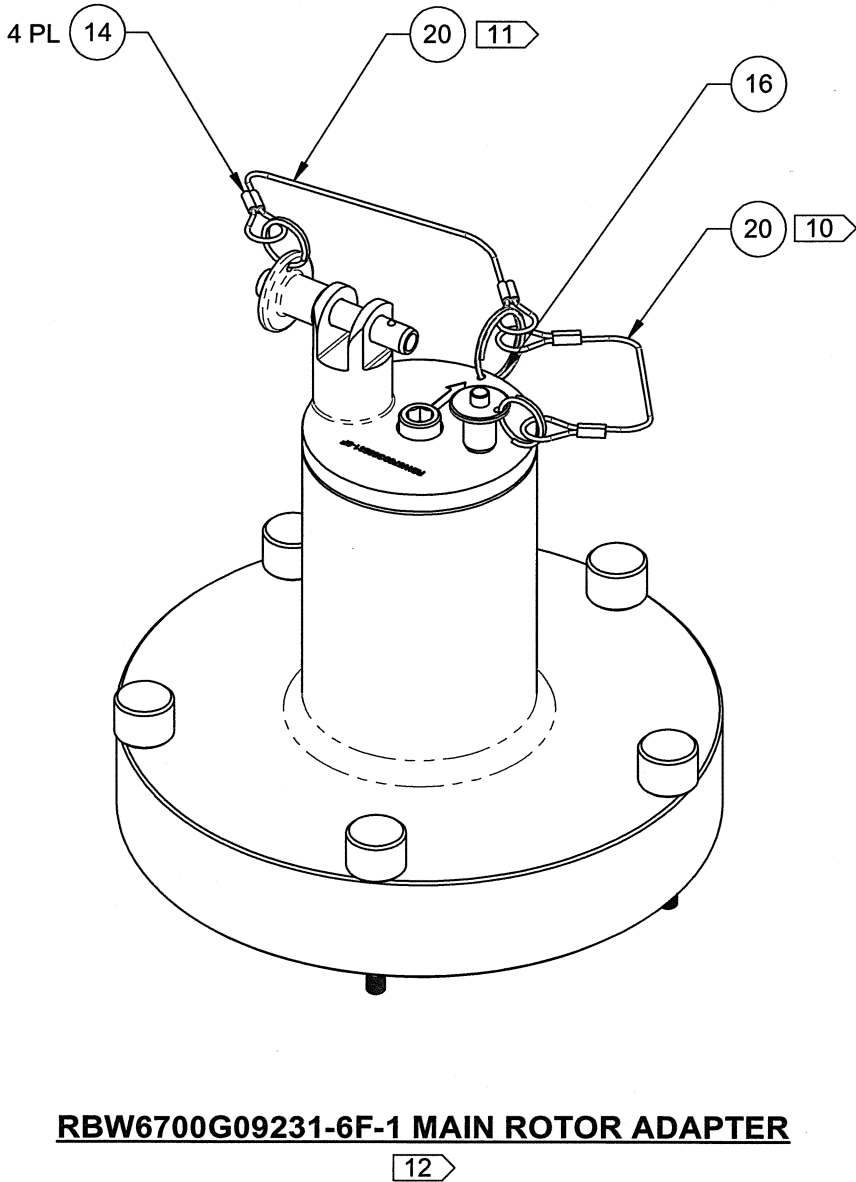
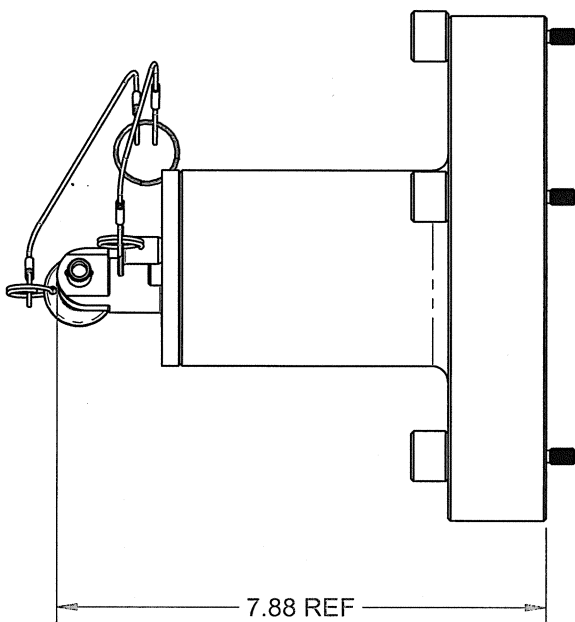
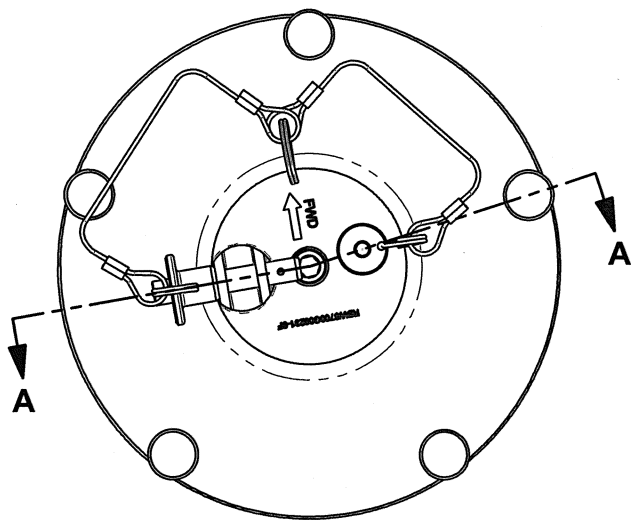


RBW6700G09231-6F M/R BLADES FLAPPING BLOCK TOOL

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A

A	NEW ISSUE	19-705	KPT
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 1 OF 15
APPROVED	WJP	TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-2	1	RBW6700G09231-6F-2	ADAPTER ASSEMBLY
-4	1	RBW6700G09231-6F-4	ALIGNMENT HUB
-5	1	RBW6700G09231-6F-5	GASKET
-6	5	RBW6700G09231-6F-6	PIN
14	4	McMaster#3896T31 OR EQUIV.	ALUMINUM WIRE ROPE COMPRESSION SLEEVE 1/16" DIA. X 3/8" LG.
15	1	McMaster#90128A364 OR EQUIV.	ZINC PLATED STEEL SOCKET HEAD SCREW 3/8"-24 X 1" LG.
16	1	McMaster#90905A655 OR EQUIV.	316 SS SPLIT RING 15/16" ID. X 1-1/16" OD. X 1/8" THK.
17	1	McMaster#90985A127 OR EQUIV.	17-4 PH SS PUSH BUTTON QUICK RELEASE PIN 1/4" DIA. X 1-1/4" USABLE LG.
18	1	McMaster#90985A311 OR EQUIV.	17-4 PH SS PUSH BUTTON QUICK RELEASE PIN 3/8" DIA. X 1" USABLE LG.
19	1	McMaster#95307A700 OR EQUIV.	CADMIUM PLATED STEEL FLANGE LOCKNUT 3/8"-24 X 9/32" HT.
20	A/R	CARR-LANE#CL-2-C	NYLON COATED STEEL LANYARD 1/16" DIA.
21	2	NTA-613	STEEL NEEDLE ROLLER THRUST BEARING 0.377" ID. X 13/16" OD. X 5/64" THK.
22	4	TRA-613	STEEL THRUST WASHER 0.377" ID. X 13/16" OD. X 0.032" THK.



RBW6700G09231-6F-1 MAIN ROTOR ADAPTER

- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) INSTALL ITEM 19 HAND TIGHT
 - 9) APPLY NICKEL ANTI-SEIZE LOCTITE LB 771 ON THREADS OF ITEM -6 THEN ASSEMBLE WITH ITEM -2, AND REMOVE EXCESS
 - 10) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 17
 - 11) ASSEMBLED LANYARD LENGTH MUST BE 6" +/- 1", LANYARD MUST MOVE FREELY WHEN INSTALLING/REMOVING ITEM 18
 - 12) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 2 OF 15
APPROVED		TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS
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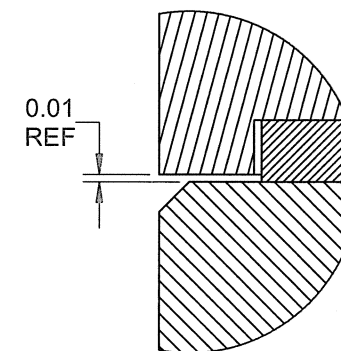
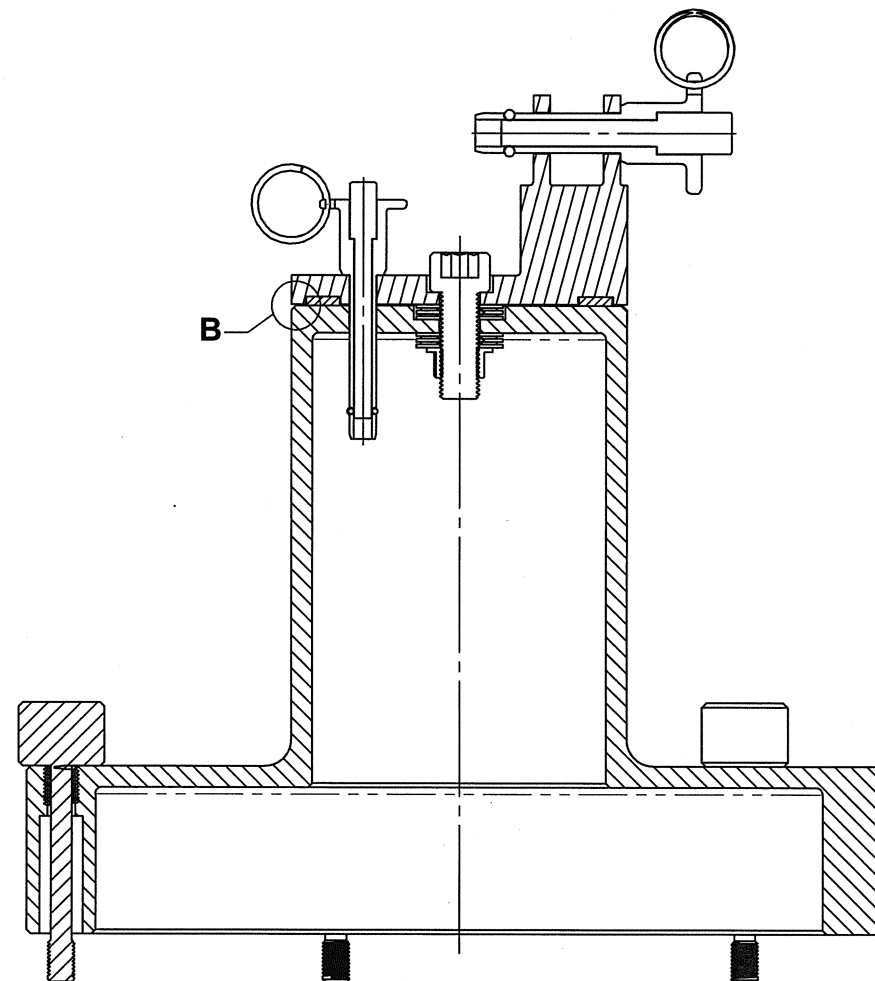
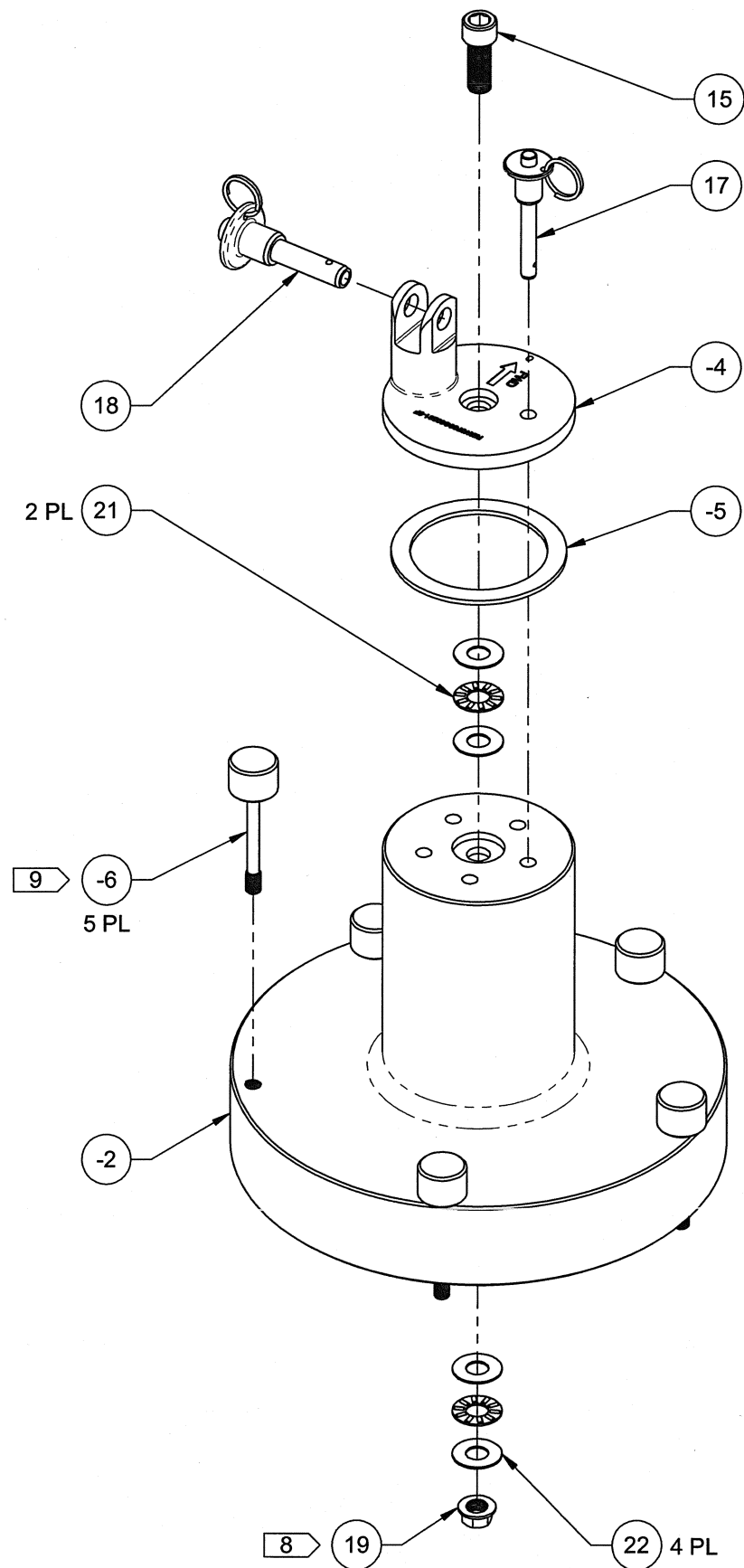
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DETAIL B



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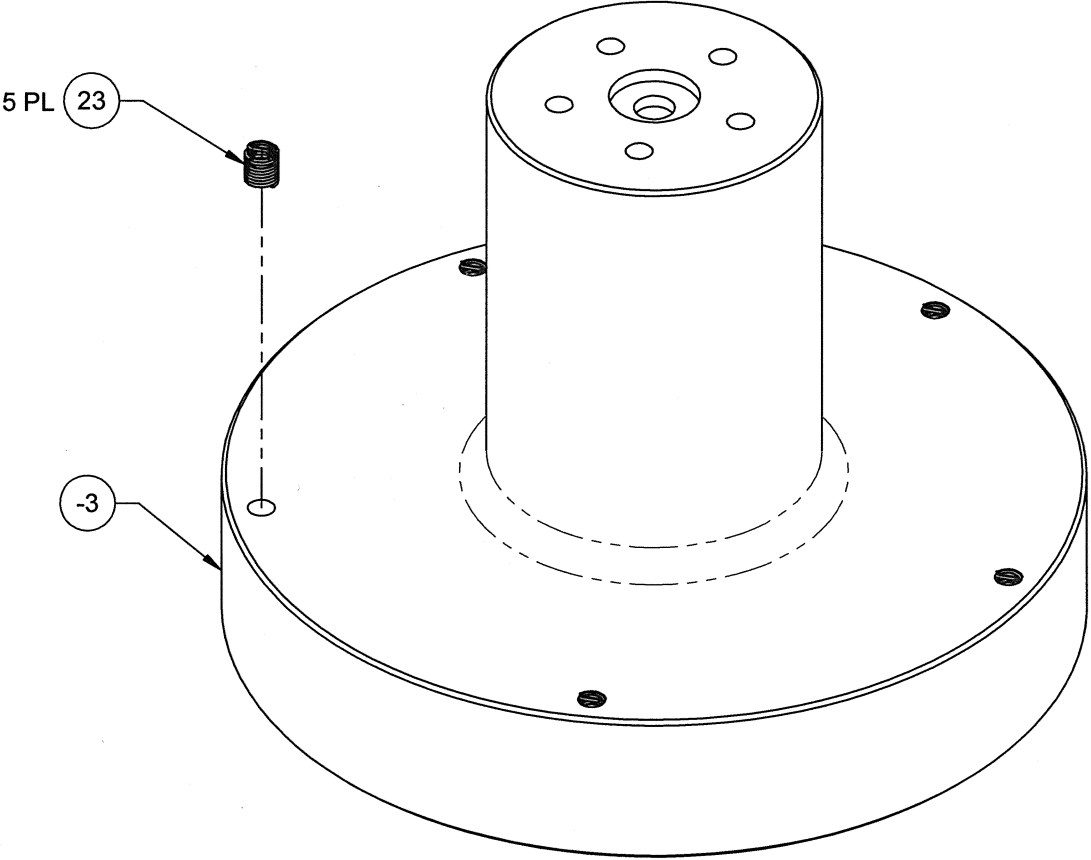
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DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 3 OF 15
APPROVED		TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS 
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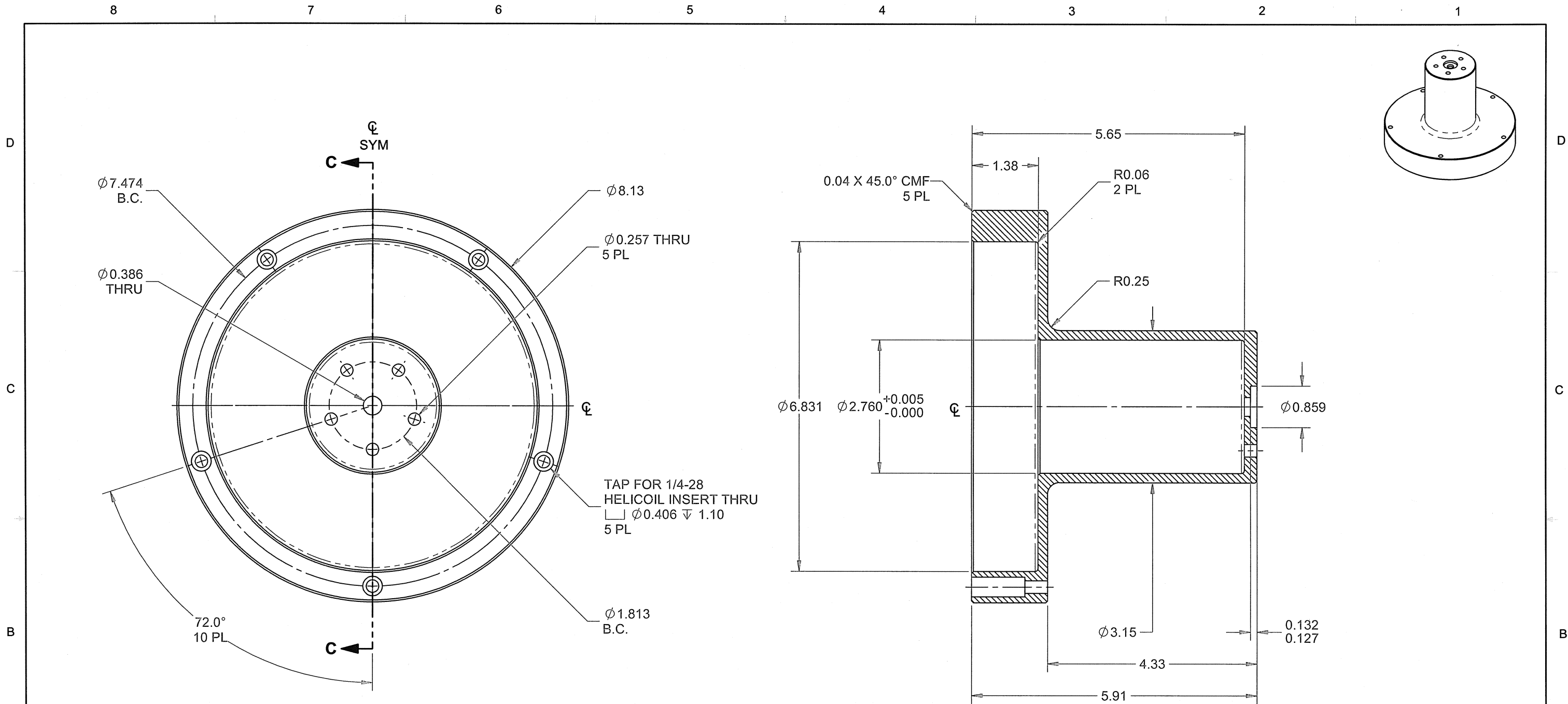
ITEM #	QTY	PART #	PART TITLE
-3	1	RBW6700G09231-6F-3	ADAPTER
23	5	McMaster#91732A232 OR EQUIV.	18-8 SS HELICAL INSERT 1/4"-28 X 3/8" LG.



RBW6700G09231-6F-2 ADAPTER ASSEMBLY

NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 4 OF 15
APPROVED		TITLE	SCALE
DATE 4/26/2019		M/R BLADES FLAPPING BLOCK TOOL	NTS
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RBW6700G09231-6F-3 ADAPTER

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 5 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DATE	4/26/2019	M/R BLADES FLAPPING BLOCK TOOL	NTS
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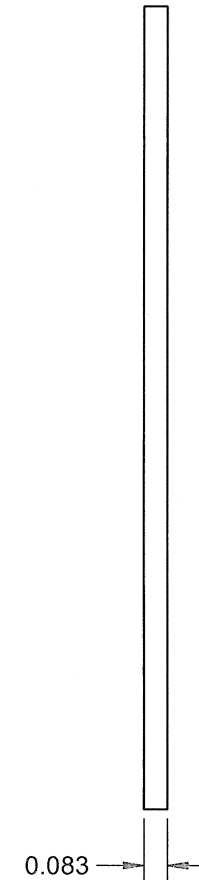
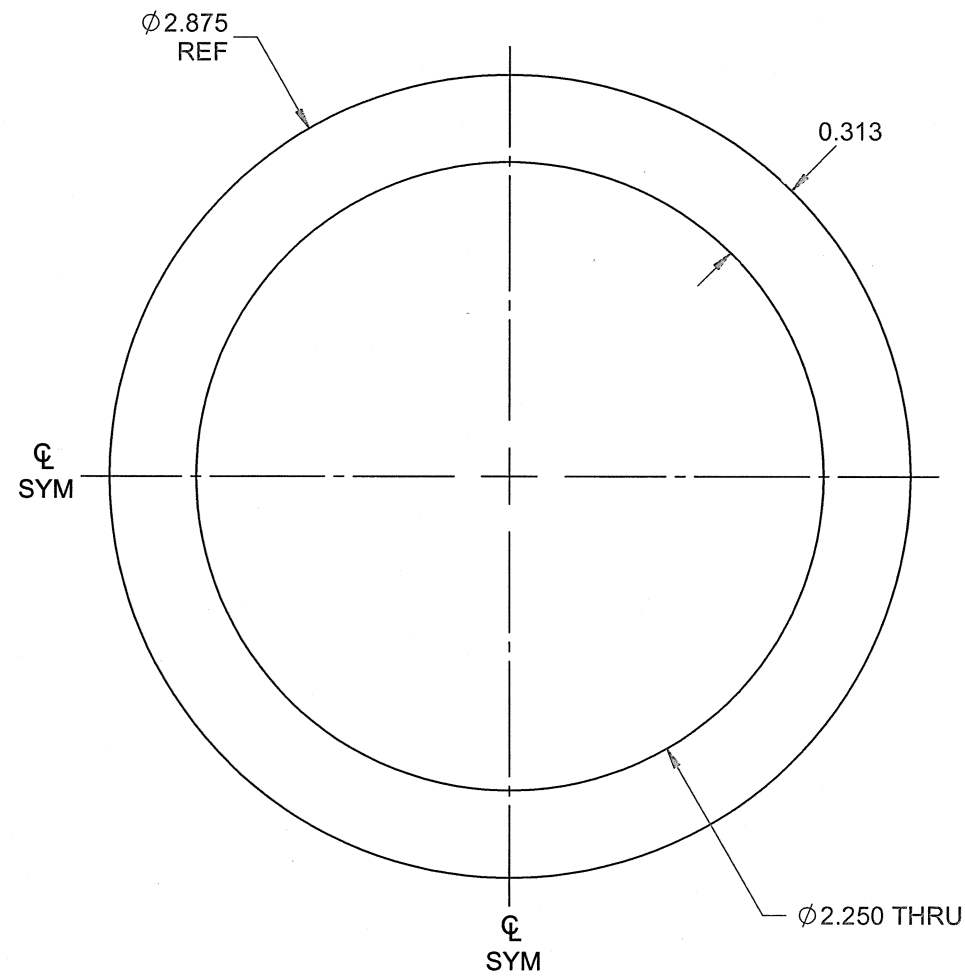
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**RBW6700G09231-6F-5 GASKET****NOTES:**

1) MATERIAL: NYLON 6 / UHMW

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 7 OF 15
APPROVED	VP	TITLE	SCALE
DATE	4/26/2019	M/R BLADES FLAPPING BLOCK TOOL	NTS
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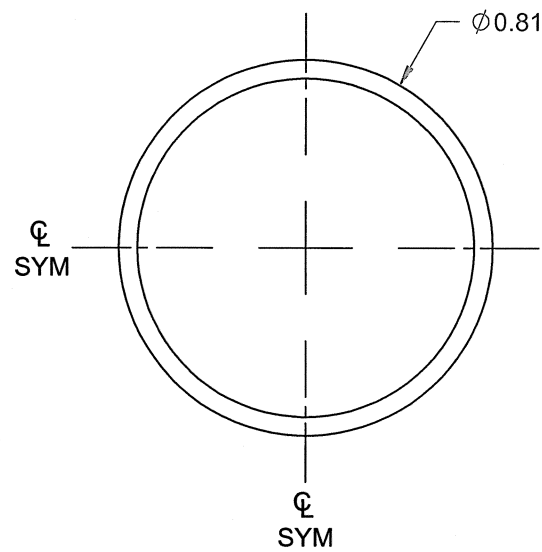
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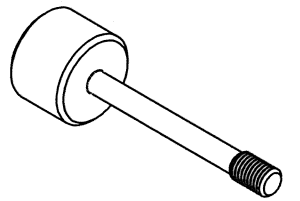
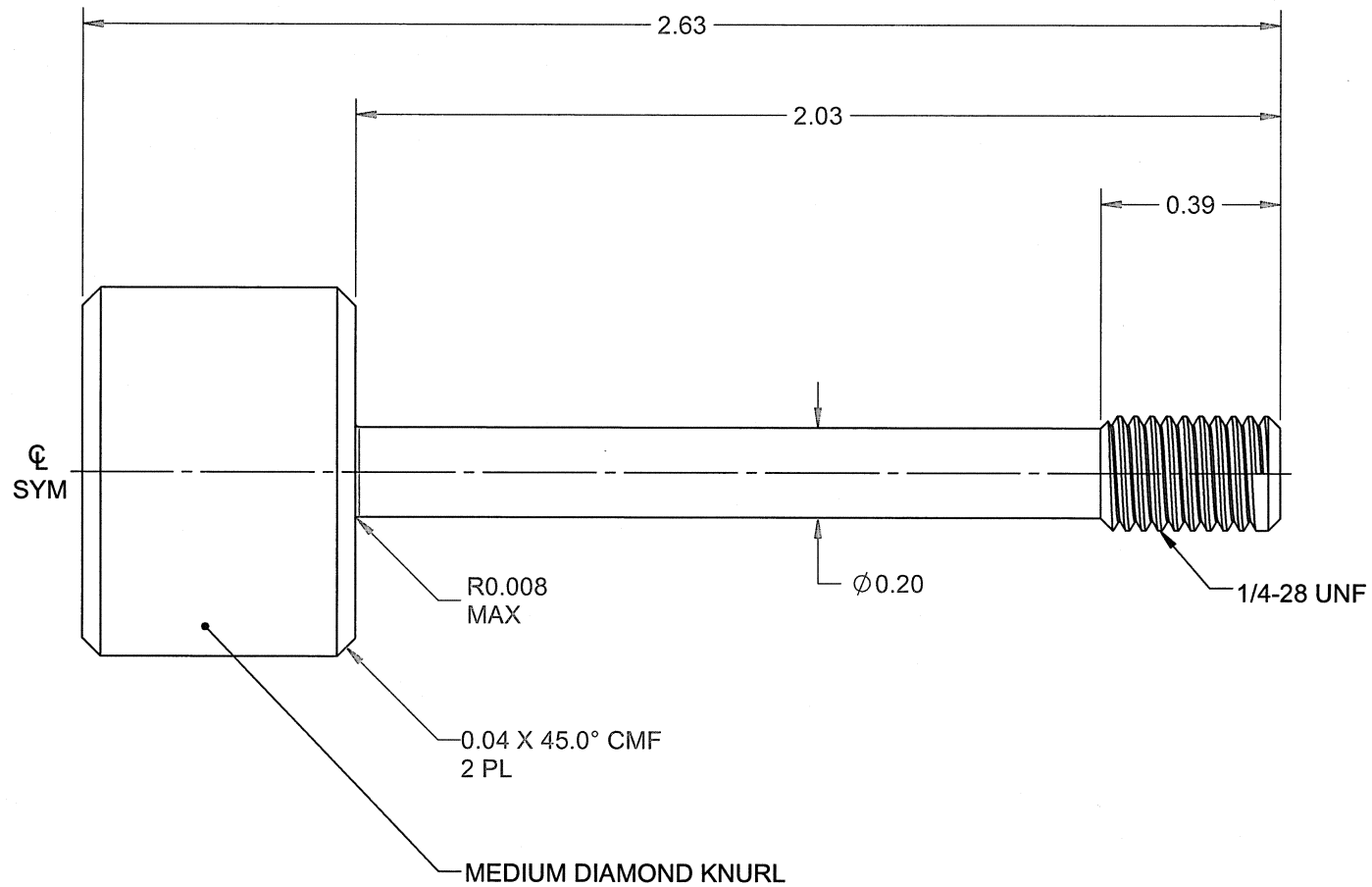
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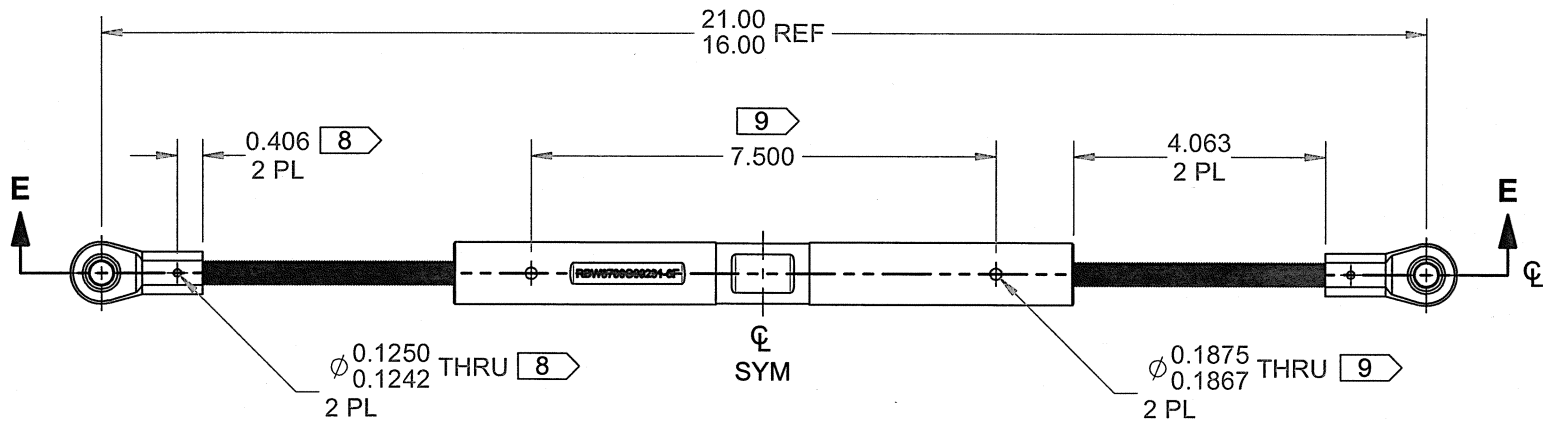
RBW6700G09231-6F PIN



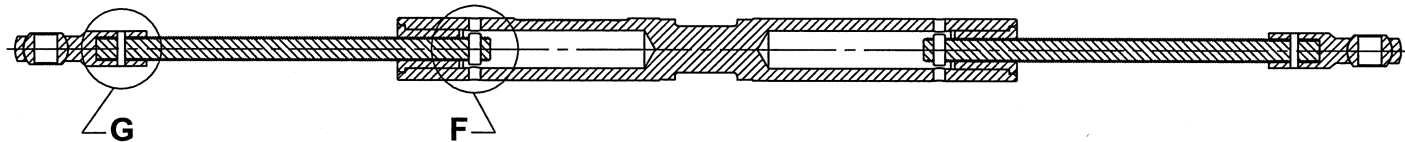
- NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL
2) HEAT TREAT: N/A
3) FINISH: N/A
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) REMOVE ALL SHARP EDGES AND BURRS
7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 8 OF 15
APPROVED		TITLE	SCALE
DATE 4/26/2019		M/R BLADES FLAPPING BLOCK TOOL	NTS
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ITEM #	QTY	PART #	PART TITLE
-8	1	RBW6700G09231-6F-8	CONNECTING ROD WELDMENT
-12	1	RBW6700G09231-6F-12	LEFT HAND SHAFT
-13	1	RBW6700G09231-6F-13	RIGHT HAND SHAFT
24	1	McMaster#1064K741 OR EQUIV.	NYLON BALL JOINT ROD END 3/8"-24 RIGHT HAND THREAD X 3/8" ID.
25	1	McMaster#1064K742 OR EQUIV.	NYLON BALL JOINT ROD END 3/8"-24 LEFT HAND THREAD X 3/8" ID.
26	2	McMaster#98381A220 OR EQUIV.	STEEL DOWEL PIN 1/8" DIA. X 9/16" LG.
27	2	McMaster#98381A505 OR EQUIV.	STEEL DOWEL PIN 3/16" DIA. X 1/2" LG.

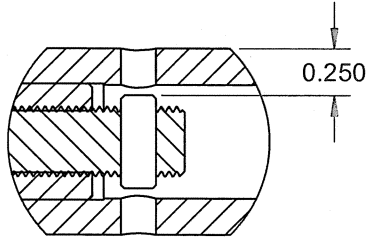
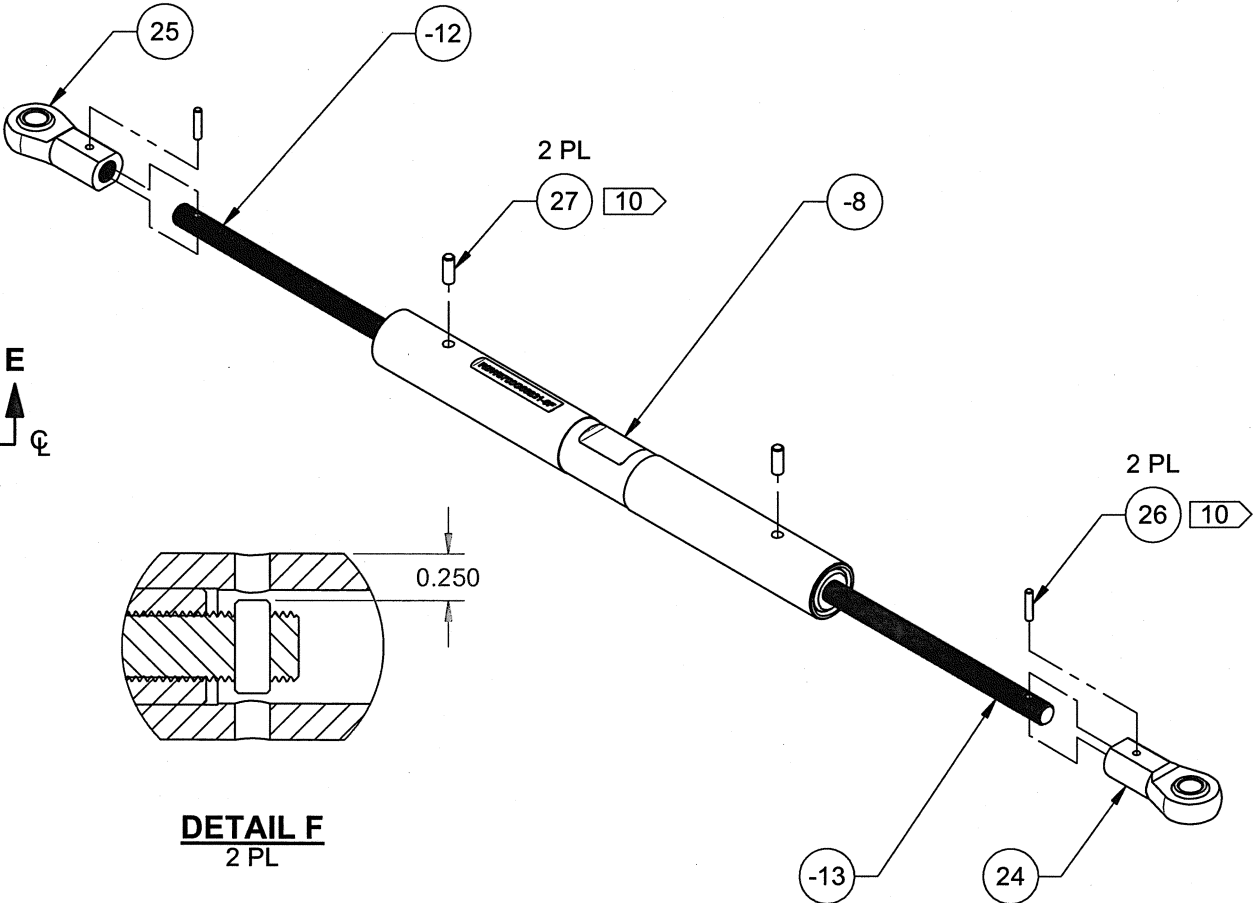


ITEMS 26 AND 27
REMOVED FOR CLARITY

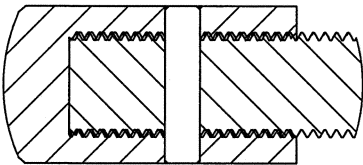


SECTION E-E

RBW6700G09231-6F-7 CONNECTING ROD





DETAIL F
2 PL

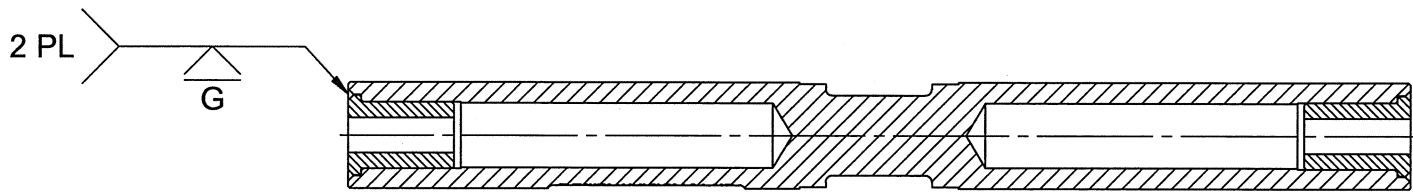


DETAIL G
2 PL

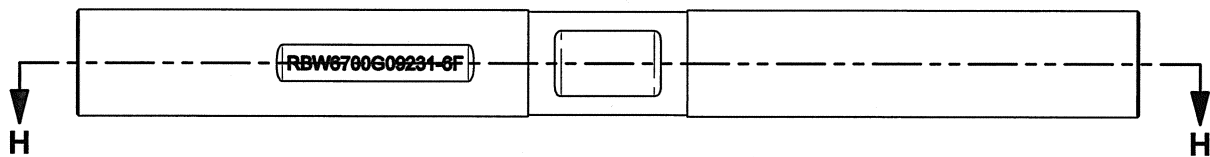
- NOTES:
- 1) MATERIAL: N/A
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) IDENTIFICATION: N/A
 - 7) ASSEMBLE AS SHOWN
 - 8) TRANSFER DRILL HOLE THROUGH ITEMS -12, -13, 24, AND 25 AS SHOWN
 - 9) TRANSFER DRILL HOLE THROUGH ITEMS -8, -12, AND -13 AS SHOWN
 - 10) APPLY RETAINING COMPOUND LOCTITE 620 OR EQUIVALENT ON MATING SURFACES THEN PRESS FIT ITEMS 26 AND 27 WITH ITEMS -12 AND -13, AS SHOWN, AND REMOVE EXCESS
 - 11) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 9 OF 15
APPROVED		TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS 
DATE	4/26/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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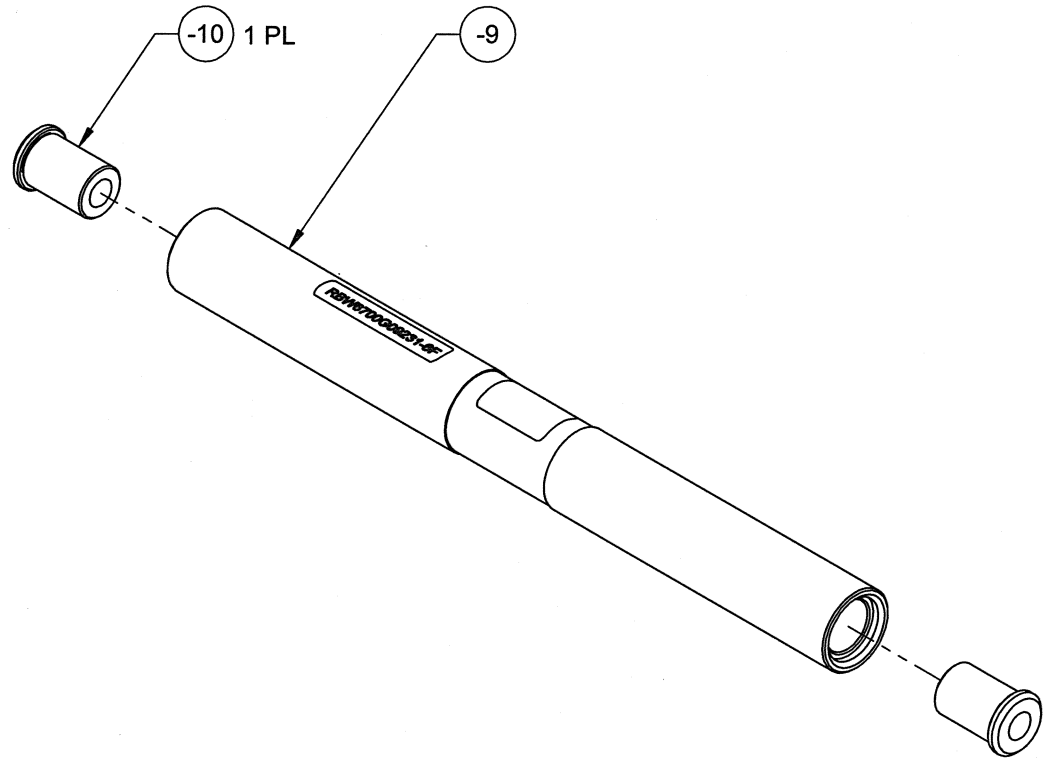
ITEM #	QTY	PART #	PART TITLE
-9	1	RBW6700G09231-6F-9	HANDLE
-10	1	RBW6700G09231-6F-10	LEFT HAND BUSHING
-11	1	RBW6700G09231-6F-11	RIGHT HAND BUSHING



SECTION H-H



RBW6700G09231-6F-8 CONNECTING ROD WELDMENT



NOTES:
1) MATERIAL: N/A
2) HEAT TREAT: N/A
3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
5) UNITS: INCHES UNLESS OTHERWISE NOTED
6) IDENTIFICATION: N/A
7) ASSEMBLE AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 10 OF 15
APPROVED		TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS
DATE	4/26/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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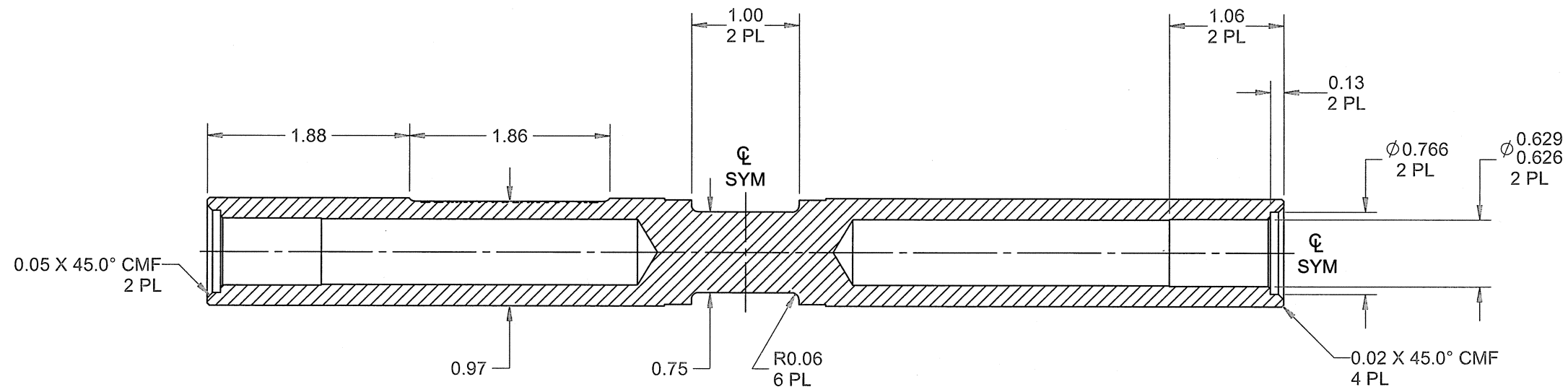
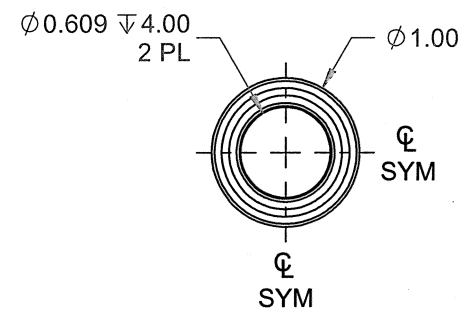
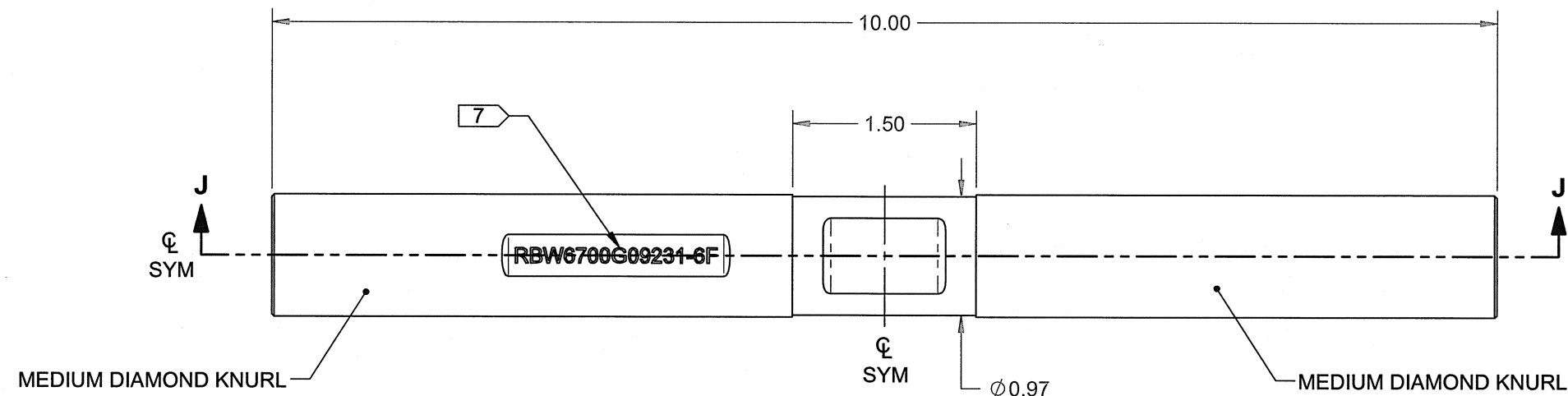
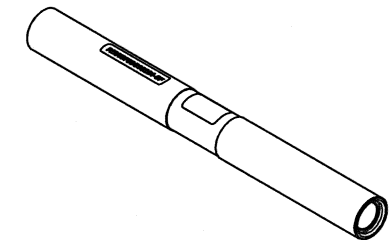
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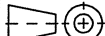


RBW6700G09231-6F-9 HANDLE

SECTION J-J

NOTES:

- 1) MATERIAL: 4140 (28-32 RC)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = ± 0.1 " / $\pm 1^\circ$
X.XX = ± 0.01 " / $\pm 0.5^\circ$
X.XXX = ± 0.005 " / $\pm 0.1^\circ$
X.XXXX = ± 0.0005 " / $\pm 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = ± 0.005 "
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: MACHINE ENGRAVE OR DOT MARK T/N, "RBW6700G09231-6F", AS SHOWN

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 11 OF 15
APPROVED		TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS 
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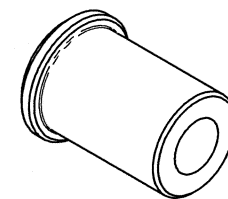
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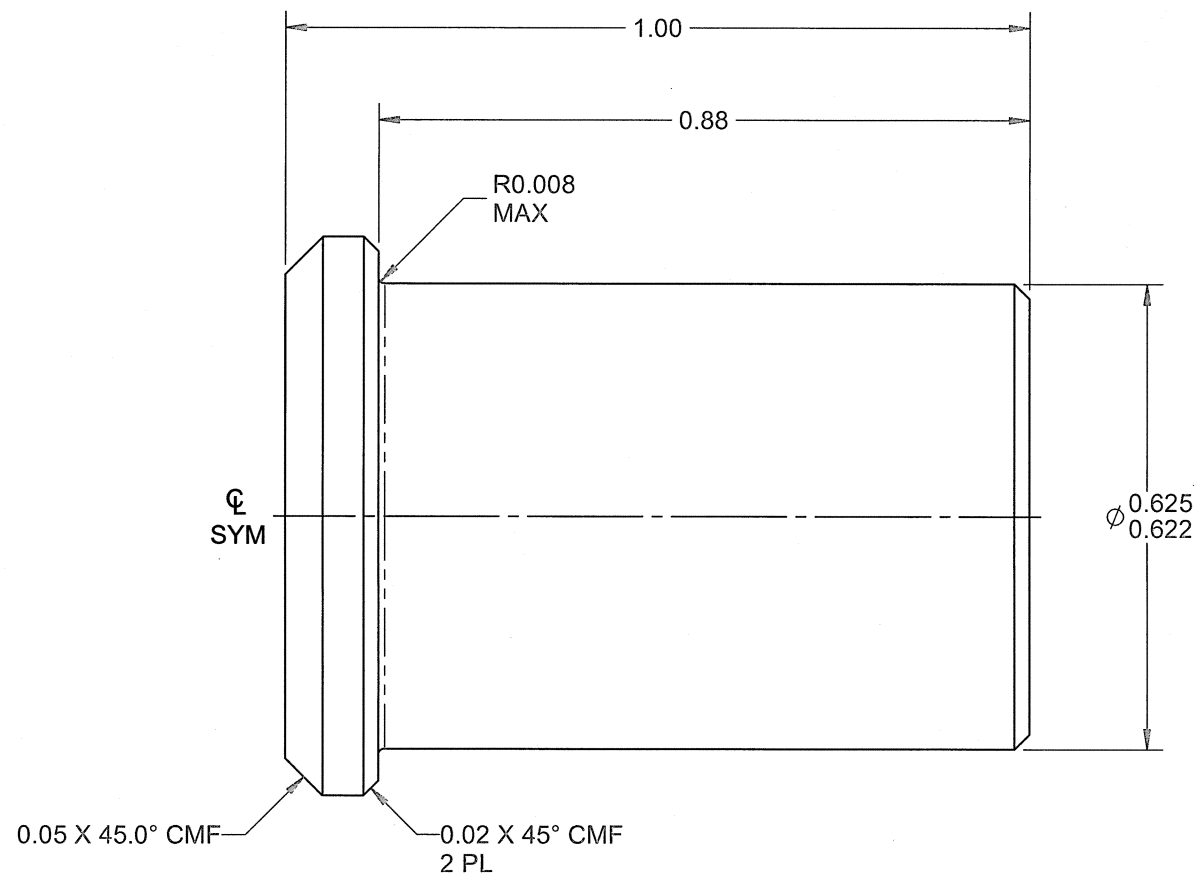
3/8-24 UNF THRU
LEFT HAND THREAD

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RBW6700G09231-6F-10 LEFT HAND BUSHING



NOTES:

1) MATERIAL: 4140 (28-32 RC)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°


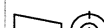
X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"

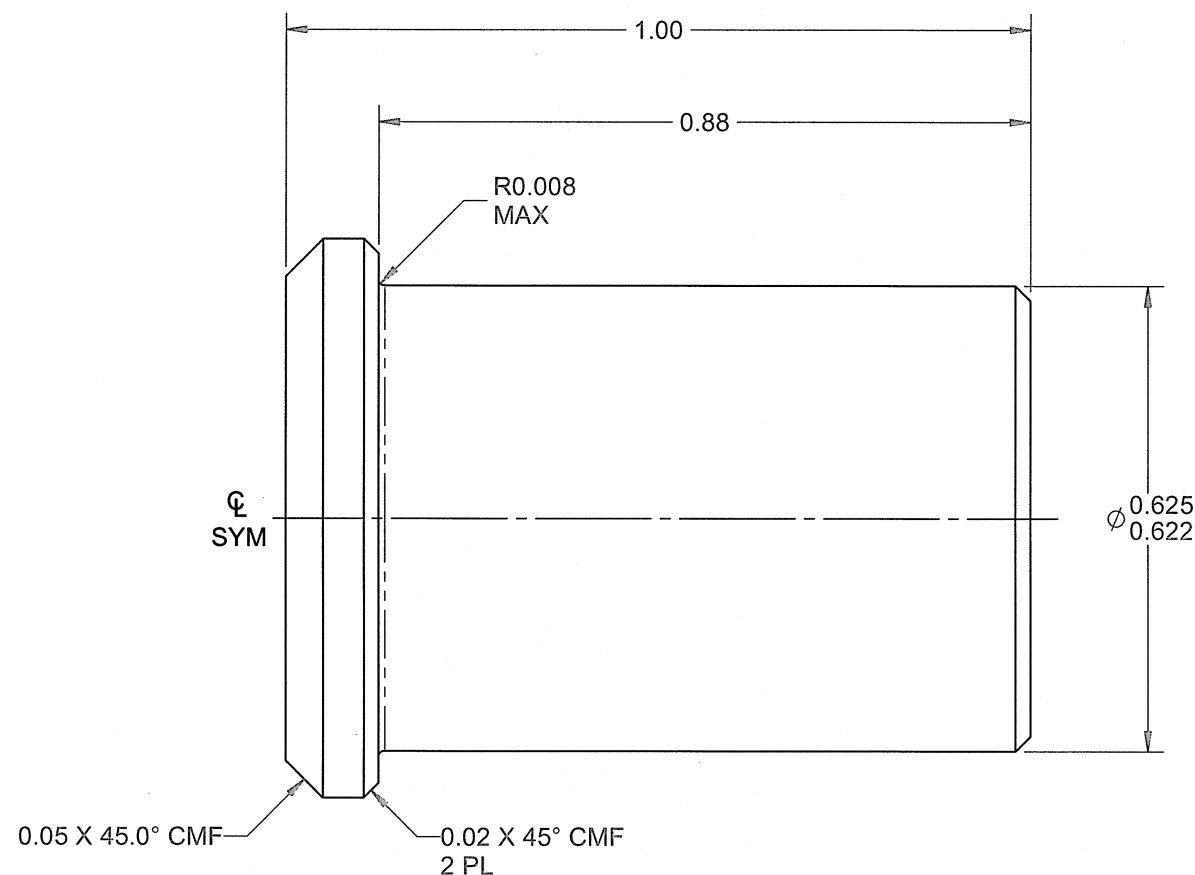
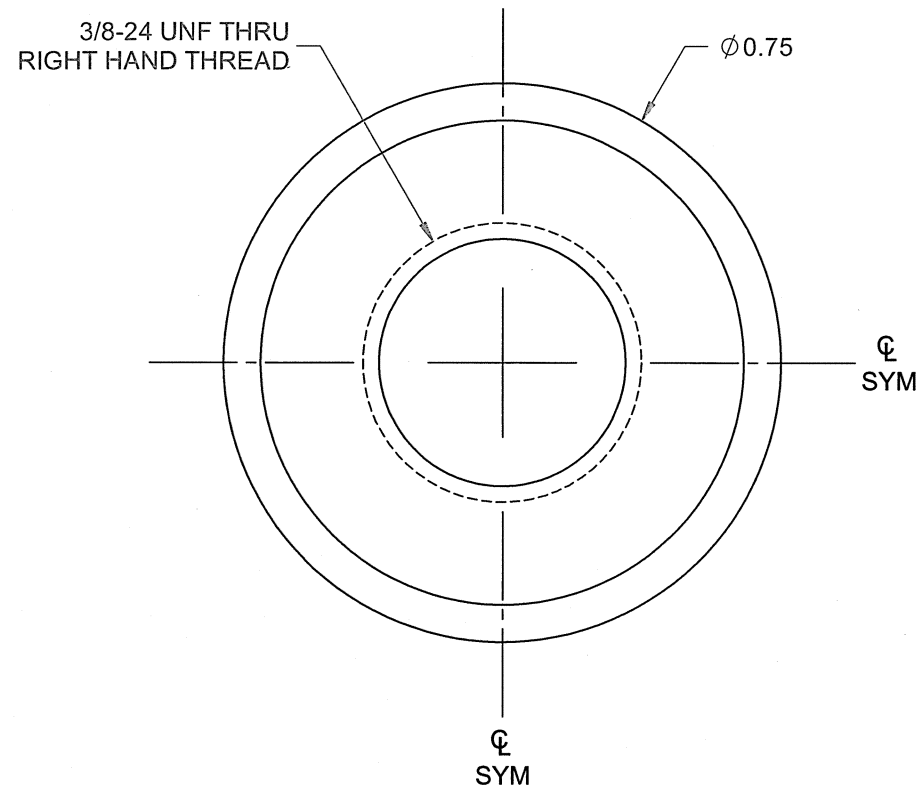
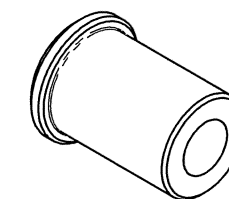
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	KPT	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 12 OF 15
APPROVED		TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS 
DATE	4/26/2019	COPYRIGHT © 2019 BY DART AEROSPACE LTD	
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RBW6700G09231-6F-11 RIGHT HAND BUSHING

- NOTES:
- 1) MATERIAL: 4140 (28-32 RC)
 - 2) HEAT TREAT: N/A
 - 3) FINISH: N/A
 - 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 13 OF 15
APPROVED	VJP	TITLE	SCALE
DATE 4/26/2019		M/R BLADES FLAPPING BLOCK TOOL	NTS
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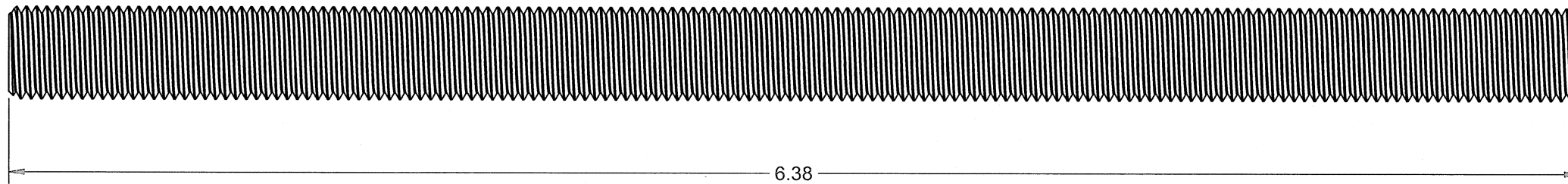
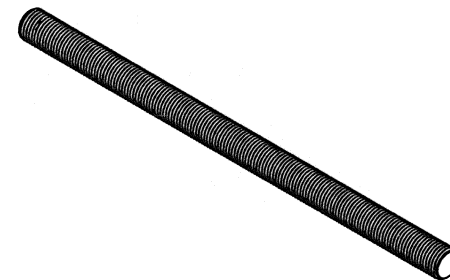
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**RBW6700G09231-6F-12 LEFT HAND SHAFT****NOTES:**

- 1) MATERIAL: McMaster#95625A017 OR EQUIV. (GRADE B7 STEEL LEFT HAND THREADED ROD 3/8"-24 X 3' LG.)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 14 OF 15
APPROVED	VY	TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS
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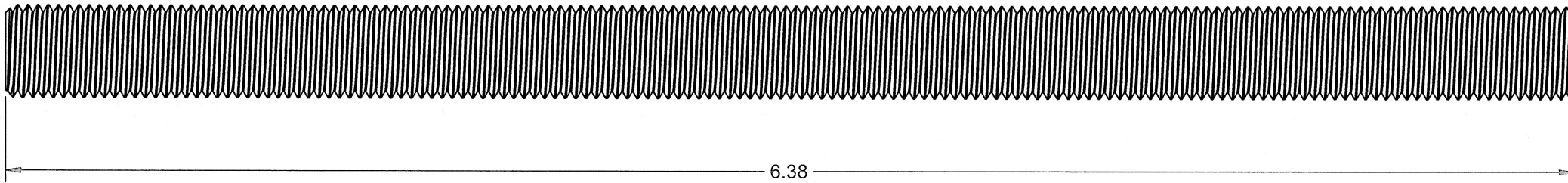
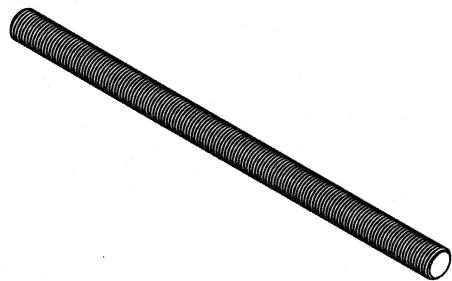
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**RBW6700G09231-6F-13 RIGHT HAND SHAFT****NOTES:**

- 1) MATERIAL: McMaster#92580A109 OR EQUIV. (GRADE B7 STEEL RIGHT HAND THREADED ROD 3/8"-24 X 3' LG.)
- 2) HEAT TREAT: N/A
- 3) FINISH: BLACK OXIDE PER MIL-C-13924 CLASS 1 THEN APPLY A THIN LAYER OF OIL / CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL-C-81309 TYPE III OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	KPT		
CHECKED	MBB	TOOL PART #	REV. A
MFG. APPR.	DP	RBW6700G09231-6F	SHEET 15 OF 15
APPROVED	<i>WPC</i>	TITLE	SCALE
		M/R BLADES FLAPPING BLOCK TOOL	NTS
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